

5151303



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE350A94-2708-01-15

Job Sheet 189268



Part No: RBE350A94-2708-01-15

Job Qty: 5 ea

Part Name: Rod Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/22/19

Job Tracking No:

Due Date: 2/8/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A94-2708-01 Rev G IPP Rev A 18.01.23 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		2/8/19	0.00	0.00	Start Up Small Fab-2		
110	Small Fab	5 pcs		2/8/19	0.00	1.00	Small Fab-3		Michel
120	QC	5 pcs		2/8/19	0.00	0.00	QC5		
121	Outsource	5 pcs		2/8/19			GRO002-VC	FEB 1 2020	
122	QC	5 pcs		2/8/19	0.00	0.00	QC6		
130	Packaging	5 pcs		2/8/19	0.00	0.00	Packaging3-1		
140	QC21-SA	5 Ea		2/8/19	0.00	0.00	QC21		

Part Op 110 - -Press fit -05 into -03 as per DWG, Sheet 3
 Descriptions: 121 - -Issue P/O to Groupe Altech; PO 42533 -Black oxide finish, MIL-C-13964, CLASS 1; MIL-C-13964 GRADE 1
 4 -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
98381A593	Dowel Pin	5 Ea (1 ea)	90-Start up Operation	5050893
RBE350A94-2708-01-03	Rod	5 pcs (1 ea)	90-Start up Operation	5135472

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	98381A593	5	35	0
	RBE350A94-2708-01-03	5	11	0

Part Specifications



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

not be found.

Plex 1/22/19 10:47 AM Dart.lajeunesse.marie

Container No: S151303



Part: RBE350A94-2708-01-15

Job No: 189268

Serial No/Batch: S151303

Revision: G

Inspector:

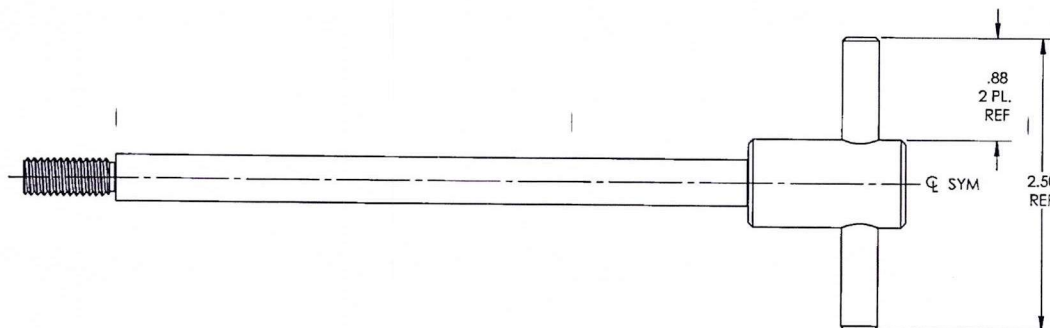
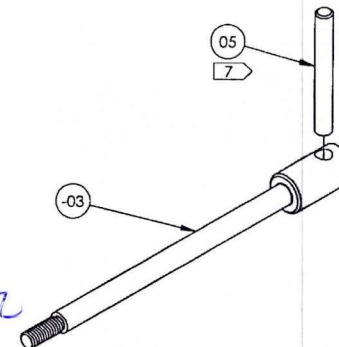
Exp Date:

Instructions:

Date: 02/06/19

ITEM #	QTY	PART #	TITLE	REV.	DESCRIPTION	ECN #	DATE	BY	APPROVED
-03	1	RBE350A94-2708-01-03	ROD	G	ASSY ADDED	17-804	01/02/2018	VM	ML
05	1	McMaster#98381A593	DOWEL PIN 5/16" x 2-1/2" LG.						

SHOW
 RETURN
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 189268 ML5
 19-01-22



RBE350A94-2708-01-15 ROD ASSY

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE (NEUTRALIZE AFTER BLACK OXIDE TREATMENT)
 - 4) SPEC: MIL-C13924, CLASS 1; MIL-C-16173 GRADE 4
 - 5) BREAK ALL SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) PRESS DOWEL INTO ROD

DART AEROSPACE		Hawkebury, Ontario, Canada	
TITLE ROD ASSY			
PART NO. RBE350A94-2708-01-15		REV G	
TOOL NO. RBE350A94-2708-01		UNLESS OTHERWISE SPECIFIED: DIMENSIONS ARE IN INCHES INTERPRET PER ASME Y14.5M-2009 DIMENSIONS APPLY AFTER FINISHING	
DESIGNED BY:	VM 01/02/2018	TOLERANCES:	FRACTIONS ± 1/8
DRAWN BY:	VM 01/02/2018	XXX ± .005	ANGLES ± .5°
CHECKED BY:	VM 01/02/2018	XX ± .01	SURFACE
MFG REVIEW BY:	DD 01/03/2018	X ± .1	ROUGHNESS
APPROVED BY:	ML 01/08/2018	SCALE: NTS	SHEET 3 OF 4
COPYRIGHT © 2017 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042533



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO042533
PO Date: 2/7/19
Due Date: 2/13/19
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189268	RBE350A94- 2708-01-15	Rod Assembly -Issue P/O: _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -	-	2/13/19	5 pcs	0 pcs	5 pcs	\$5.7142857/pcs	\$28.57
2	188716	RBT18560- 11	Upright -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed -	-	2/13/19	16 pcs	0 pcs	16 pcs	\$5.7142857/pcs	\$91.43

Line Item Note ** Need for Feb 12, is this possible? **

Grand Total: \$120.00

Plex 2/8/19 12:55 PM dart.tsimiklis.chrisoula



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO042533



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

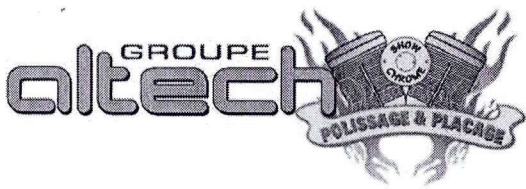
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 2/8/19 12:55 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016675-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016675 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
12-Feb-2019		Aman		042533				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-2708-01-15 Rev.	RBE350A94-2708-01-15 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13964C, CLASS 1 MIL-C-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	5	5	0	0	0
2	RBT18560-11 Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	16	16	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.